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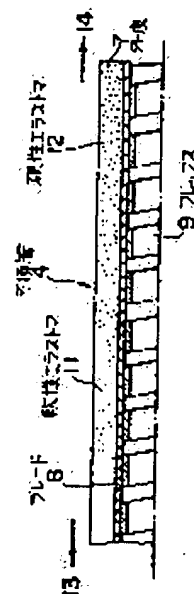
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## (54) FLEXIBLE TUBE FOR ENDOSCOPE AND ITS MANUFACTURE

(57)Abstract:

PURPOSE: To freely vary the flexibility of a desired part by forming an outer layer of a flexible tube for an endoscope with a mixture of plural resins of different hardness, and varying arbitrarily its mixing ratio.

CONSTITUTION: A flexible tube 4 is constituted of a flex (spiral tube) 9 formed by winding spirally an elastic band-like plate, a braid (net tube) 8 braided by a metallic fine wire for covering this flex 9, and a skin 7 consisting of elastomer allowed to adhere extending over the whole periphery of the outside surface of the blade 8. The skin 7 which covers the outside peripheral surface of the braid 8 is formed by mixing soft elastomer 11 and hard elastomer 12. Its mixing ratio is formed so that a ratio of the hard elastomer 12 becomes higher gradually toward an operating part body side 14. That is, as for a tip constituting part side 13, the soft elastomer 11 and the hard elastomer 12 are mixed by a large quantity and a small quantity, respectively since the flexibility is necessary.



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